

000538



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.4001

Job Sheet 170442



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/26/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

-Ship Via: TBA - to be advised

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		2/26/18	0.00	0.00	Start Up Stores/Pkg-1		FEB 06 2018
110	Packaging	1 pcs		2/26/18	0.00	0.00	Packaging1-1		MAR 02 2018
120	QC	1 pcs		2/26/18	0.00	0.00	QC4		
125	DC	1 pcs		2/26/18	0.00	0.00	DC		
130	Packaging	1 pcs		2/26/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		2/26/18	0.00	0.00	QC21		18/03/18

Part Op 125 - Photocopy bluefile & type labels per PPP 646.4001

Descriptions: 130 - Identify and pack for shipping as per PPP 646.4001 Location: F102

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	600.0129	8	552	0	0
	600.0990	1	25	0	0
	600.0991	1	27	0	0
	600.1012	1	55	0	0
	600.1013	5	105	0	0
	646.2910	1	12	0	0
	646.3001	1	4	0	0
	646.3110	1	7	0	0
	646.3210	1	11	0	0
	646.3301	1	10	0	0
	646.3510	1	19	0	0
	646.3511	1	7	0	0
	646.3610	1	22	0	0
	646.3710	1	29	0	0
	646.3711	1	17	0	0
	646.3712	1	31	0	0
	646.3713	1	27	0	0
	646.3714	1	29	0	0
	646.3715	2	44	0	0
	646.3716	1	24	0	0
	646.3717	1	29	0	0
	646.3718	2	40	0	0
	646.3719	2	18	0	0
	646.3810	2	17	0	0



A Closed: _____ Date: _____ Work Order update only ☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation			

02/06/18 Job No: 170442

PART NO:
Original Serial #: S039717
Revision:
Operation:
Change No:

AS350 Cable Cutter System

MRB (QSI042) Approval
Completed By
Lead hand / Supervisor Approval Verification
QC / QA Coordinator Approval

Root Cause		Defect		Other	
Environment	☐ No Re-verification	☐ Positioning	☐ Positioning	☐ Positioning	☐ Positioning
Design	☐ Operator	☐ Outside Dimensions	☐ Outside Dimensions	☐ Outside Dimensions	☐ Outside Dimensions
Doc/Data	☐ Offset/Setup	☐ Over/Under tolerance	☐ Over/Under tolerance	☐ Over/Under tolerance	☐ Over/Under tolerance
Equip/Tooling	☐ Supplier	☐ Part Incorrect	☐ Part Incorrect	☐ Part Incorrect	☐ Part Incorrect
Handling/Pre	☐ Training	☐ Part Lost/Missing	☐ Part Lost/Missing	☐ Part Lost/Missing	☐ Part Lost/Missing
Material	☐ Use for Testing	☐ Part Moved	☐ Part Moved	☐ Part Moved	☐ Part Moved
Internal Transport	☐ Poor Information	☐ Drawing	☐ Drawing	☐ Drawing	☐ Drawing
Technical Knowledge	☐ Rushing	☐ Finish	☐ Finish	☐ Finish	☐ Finish
LOA	☐ Product Improvement	☐ Misread	☐ Misread	☐ Misread	☐ Misread
Substation	☐ Process Improvement	☐ Turning Sequence	☐ Turning Sequence	☐ Turning Sequence	☐ Turning Sequence
Past Expiry Date	☐ Manufacturing Process				
Misidentified	☐ Past Due				
OTHER :					

646.3811	1	14	0	0
646.3812	2	13	0	0
646.3813	1	12	0	0
646.3910	4	40	0	0
646.3911	1	18	0	0
646.3912	4	42	0	0
646.3913 106	1	32	0	0
646.9410 CH	1	36	0	0
647.0112	2	129	0	0
647.7703	2	18	0	0
650.9201	2	21	0	0
AN3-11A	10	577	0	0
AN3-12A	2	80	0	0
AN3-13A	1	24	0	0
AN3-3A	4	380	0	0
AN3-4A	10	451	0	0
AN3-5A	2	351	0	0
AN3-6A	2	251	0	0
AN316C4R	2	64	0	0
AN44-5A	2	33	0	0
AN4C7A	2	151	0	0
AN665-34R	2	66	0	0
CCR264SS3-02	36	587	0	0
CR3213-5-3	14	328	0	0
MS20426AD5-7	2	1,291	0	0
MS20470AD5-5.5	8	501	0	0
MS20470AD5-6	8	375	0	0
MS20470AD5-7	3	245	0	0
MS21042-08	2	0	0	0
MS21042L3	63	3,006	0	0
MS21042L4	2	3,183	0	0
MS21047-3	18	788	0	0
MS24693-C278	5	130	0	0
MS24694-S51	5	513	0	0
MS24694-S54	2	226	0	0
MS24694-S55	3	129	0	0
MS27039-08-13	2	521	0	0
MS27039-1-10	2	451	0	0
MS27039-1-12	6	269	0	0
MS27039-1-16	24	500	0	0
MS27039-1-19	22	425	0	0
MS27039-1-20	2	105	0	0
MS27039-1-21	4	63	0	0
NAS1149F0332P	144	5,443	0	0
NAS1149F0363P	2	294	0	0
NAS1149F0432P	4	1,074	0	0
NAS1149FN832P	4	6,714	0	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

QA: _____ Date: _____

A Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

ate : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Technical Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Master Unit 000538

Tel (613) 632-5200

Containers on Master Unit 000538				
Serial No	Part No	Customer Part No	Status	Quantity
S039588	600.0129	600.0129	Allocated	8
S039708	600.0990	600.0990	Allocated	1
S039707	600.0991	600.0991	Allocated	1
S039587	600.1012		Allocated	1
S039586	600.1013	600.1013	Allocated	5
S039585	646.2910	646.2910	Allocated	1
S023060	646.3110	646.3110	Allocated	1
S039582	646.3210	646.3210	Allocated	1
S039581	646.3301	646.3301	Allocated	1
S039579	646.3510	646.3510	Allocated	1
S040285	646.3511	646.3511	Allocated	1
S039575	646.3610	646.3610	Allocated	1
S039574	646.3710	646.3710	Allocated	1
S039568	646.3712	646.3712	Allocated	1
S039567	646.3713		Allocated	1
S039564	646.3714	646.3714	Allocated	1
S039557	646.3715		Allocated	2
S039554	646.3716		Allocated	1
S039552	646.3717		Allocated	1
S039551	646.3718		Allocated	2
S039548	646.3719		Allocated	2
S039546	646.3810		Allocated	2
S039545	646.3811		Allocated	1
S019892	646.3813		Allocated	1
S039542	646.3910		Allocated	4
S039541	646.3911		Allocated	1
S039538	646.3912		Allocated	4
S039532	646.3913		Allocated	1
S039527	646.9410		Allocated	1
S039529	650.9201		Allocated	2
S039523	AN3-11A		Allocated	10
S039521	AN3-12A		Allocated	2
S039518	AN3-13A		Allocated	1

03/2018
07/2018
exp. 03/2018

S027109
S030952
S010382
S010385
S002104

F159851
F159846

S039517	AN3-3A	AN3-3A	Allocated	4
S039508	AN3-4A		Allocated	10
S039507	AN3-5A	AN3-5A	Allocated	2
S039502	AN3-6A	AN3-6A	Allocated	2
S039498	AN316C4R	AN316C4R	Allocated	2
S039494	AN44-5A	AN44-5A	Allocated	2
S039493	AN4C7A		Allocated	2
S039489	AN665-34R	AN665-34R	Allocated	2
S039485	CCR264SS3-02		Allocated	36
S039484	CR3213-5-3		Allocated	14
S039481	MS20426AD5-7		Allocated	2
S039479	MS20470AD5-5.5		Allocated	8
S039474	MS20470AD5-6	MS20470AD5-6	Allocated	8
S039473	MS20470AD5-7		Allocated	3
S039516	MS21042L08		Allocated	2
S039470	MS21042L3	MS21042L3	Allocated	63
S039468	MS21042L4	MS21042L4	Allocated	2
S039461	MS21047-3		Allocated	18
S039463	MS24693-C278		Allocated	5
S039459	MS24694-S51		Allocated	5
S039458	MS24694-S54		Allocated	2
S039457	MS24694-S55	MS24694-S55	Allocated	3
S039456	MS27039-08-13	MS27039-08-13	Allocated	2
S039455	MS27039-1-10		Allocated	2
S039454	MS27039-1-12		Allocated	6
S039426	MS27039-1-16		Allocated	24
FM138238-2	MS27039-1-19		Allocated	11
S039451	MS27039-1-19		Allocated	11
S039422	MS27039-1-20		Allocated	2
S039420	MS27039-1-21		Allocated	4
S039415	NAS1149F0332P		Allocated	144
S039412	NAS1149F0363P		Allocated	2
S039411	NAS1149F0432P		Allocated	4
S039410	NAS1149FN832P		Allocated	4

110

646.3001 x1 5041210 → 5038952

646.3512 x2

646.3711 x1 5044963

647.0112 x2 5044964

647.0513

647.7703

5044959 5034597 x2

REFERENCE ONLY

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT, REMOVE
SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78
SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY
REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 &
F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(s)

05304

5	5	5	78	601.3875	SCREW	MMS1402-1A				
1	1	1	77	646.9410	SHIM	△				
	4	4	76	601.2764	WASHER	MMS1402-1A				
	2	2	75	601.2973	LOCKNUT	MMS1402-1A				
	2	2	74	601.2988	SCREW	MMS1402-1A				
	2	2	73	601.2943	LOCKNUT	MMS1402-1A				
	2	2	72	601.3128	NUT	MMS1402-1A				
	2	2	71	601.3209	LOCKNUT	MMS1402-1A				
	4	4	70	601.2638	WASHER	MMS1402-1A				
	2	2	69	601.2669	BOLT	MMS1402-1A				
	2	2	68	601.3119	CLEVIS	MMS1402-1A				
	2	2	67	601.3121	EYE BOLT	MMS1402-1A				
	2	2	66	630.9201	EYE BRACKET ASSY	MMS1402-1A				
REF	REF	REF	65	647.5701	GPS MOUNT KIT	△				
		2	64	601.3151	WASHER	MMS1402-1A				
			63	601.2911	SCREW	MMS1402-1A				
	24	24	62	601.2637	SCREW	MMS1402-1A				
2	2	2	61	601.2763	BOLT	MMS1402-1A				
	1	1	60	646.3913	SHIM	MMS1402-1A				
	4	4	59	646.3912	SHIM	MMS1402-1A				
	1	1	58	646.3911	SHIM	MMS1402-1A				
	4	4	57	646.3910	SHIM	MMS1402-1A				
	5	5	56	600.1013	PRIMER	MMS1402-1A				
	5 FT	5 FT	55	600.0129	VHB TAPE	MMS1402-1A				
	1	1	54	600.1012	SEALANT	MMS1402-1A				
	1	1	53	600.0991	MAGNETIC BOND 6398 PART B	△				
	1	1	52	600.0990	MAGNETIC BOND 6398 PART A	△				
6	10	10	51	601.2826	BOLT	MMS1402-1A				
		2	50	646.3814	WIPER BRACKET	MMS1402-1A				
		2	49	601.2910	SCREW	MMS1402-1A				
	2	2	48	601.1365	SCREW	MMS1402-1A				
	2	2	47	646.3719	DOUBLER	MMS1402-1A				
		2	46	646.3718	CUSTOM WASHER	MMS1402-1A				
	1	1	45	646.3717	DOUBLER	MMS1402-1A				
	22	22	44	601.1948	SCREW	MMS1402-1A				
	2	2	43	601.1952	SCREW	MMS1402-1A				
	4	4	42	601.1956	SCREW	MMS1402-1A				
4036	4035	4034	4033	4032	4031	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 05304, DESIG. 05304 & 05305	03/08/2016	P. BRAVO
B	INCORPORATED ECN 05304, DESIG. 05304 & 05305	11/04/2014	P. BRAVO
C	INCORPORATED ECN 05305	01/05/2015	P. BRAVO

			2	2	41	601.2829	SCREW	MS20494A54		
			2	2	40	601.2831	RIVET	MS20405A5-7		
			1	1	39	646.3716	GAUGE BRACKET			
			6	6	38	601.1953	SCREW	MS2039-1-12		
		2		2	37	646.3715	STRUT DOUBLER			
	2		2	2	36	601.2824	BOLT	AN6-5A		
12	36			36	35	601.2277	RIVET	CC10485-3-03		
6	18			18	34	600.0795	NUTPLATE	MS20407-3		
3	3			3	33	601.2565	RIVET	MS20410A5-7		
1	1			1	32	646.3813	STRUT BRACKET			
4	4			4	31	601.2822	BOLT	AN6-3A		
2	2			2	30	646.3812	GUSSET BRACKET			
8	8			8	29	601.2564	RIVET	MS20410A5-6		
1	1			1	28	646.3714	GUSSET			
	1	1		1	27	646.3610	FILLER			
	3	3		3	26	601.2830	SCREW	MS20495-5		
	2	2		2	25	601.2825	BOLT	AN6-4A		
	1	1		1	24	646.3811	RADIUS BLOCK			
	1	1		1	23	646.3712	CLIP			
	1	1		1	22	646.3711	CLIP			
8	8			8	21	601.2832	RIVET	MS20410A5-4A		
14	14			14	20	601.2020	RIVET	CR1213-5-3		
4	6	4	6	10	19	601.2823	BOLT	AN6-4A		
	1	1	1	1	18	601.2827	BOLT	AN6-3A		
	5	5		5	17	601.2912	SCREW	MS20495-1		
1	1			1	16	646.3713	GUSSET			
1	1			1	15	646.3210	SUPPORT			
	1			1	14	646.3710	DOUBLER			
	1	1		1	13	646.3110	CHANNEL			
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS20404-3	
16	32	18	120	16	144	11	601.1607	WASHER	MS20495-0P	
						10	646.3410	LH WIPER DEFLECTOR		
						9	646.3411	RH WIPER DEFLECTOR		
		2		2	8	8	647.7703	STRUT ASSY		
		2		2	7	7	647.0112	STRUT BRACKET		
	1	1		1	6	6	646.3511	STRUT		
	1	1		1	5	5	646.3510	STRUT		
2	2			2	4	4	646.3810	BRACKET		
		1		1	3	3	646.2910	DEFLECTOR		
	1			1	2	2	646.3001	LOWER CUTTER ASSY		
		1		1	1	1	646.3301	UPPER CUTTER ASSY		
X							646.4006	LOWER CUTTER FIXED PROVISIONS		
	X						646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X					646.4004	FIXED PROVISIONS KIT		
			X				646.4003	CABLE CUTTERS KIT WITH HOUR FIXED PROVISIONS		
				X			646.4002	AS350 WIPER DEFLECTOR KIT		
					X		646.4001	AS350 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MAT.	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE: 05-27-08	
		DESIGNED BY: J. BRAVO	
		DRAWING APPROVAL: J. BRAVO	
		GENERAL: 101	
		ANES OTHERWISE SPEC'D	
		DIMENSIONS ARE IN INCHES	
		3 PLACES DECIMALS 1.000	
		2 PLACES DECIMALS 2.000	
		2 PLACES DECIMALS 3.000	
		2 PLACES DECIMALS 4.000	
		2 PLACES DECIMALS 5.000	
		2 PLACES DECIMALS 6.000	
		2 PLACES DECIMALS 7.000	
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		2 PLACES DECIMALS 100.000	

DART AEROSPACE
3030 ENTERPRISE CT.
SUITE A
VISTA, CA 92081
(760)-724-5300

AS350 CABLE CUTTERS KIT
REV. 07/12/16
SCALE: NONE
SHEET 1 OF 5